



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2842-041

Job Sheet 200878



Part No: D2842-041

Job Qty: 2 pcs

Part Name: Step Assembly, LH, 206 Float



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	2 pcs	10/31/19		0.00	2.94	Large Fab - 1		Jug / SLA
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 5	2 pcs	10/31/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		

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120 Large Fab - Steps - 2 - B4B	2 pcs	10/31/19	0.00 2.94	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	SL
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
130 QC 9	2 pcs	10/31/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	DAS 24 9-89
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
140 QC 5	2 pcs	10/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS 24 9-89
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical- B4B	2 pcs	10/31/19	0.00 0.74	Handfinish - 1 - 1 - B4B	REB 19-10-07
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	

					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					160 QC 7	2 pcs
QC 7 - 13						
QC 7 - 14						
QC 7 - 15						
QC 7 - 17						
QC 7 - 18						
QC 7 - 19						
QC 7 - 2						
QC 7 - 28						
QC 7 - 3						
QC 7 - 30						
QC 7 - 34						
QC 7 - 36						
QC 7 - 37						
QC 7 - 41						
QC 7 - 47						
QC 7 - 48						
QC 7 - 51						
QC 7 - 58						
QC 7 - 59						
QC 7 - 60						
QC 7 - 9						
QC 7 - 68						
QC 7 - 50						
QC 7 - 67						
QC 7 - 40						
QC 7 - 24						
QC 7 - 43	DAS					
QC 7 - 61	81					
QC 7 - 81	9-89					
QC 7 - 76						
170 Large Fab - Steps - 3 - B4B	2 pcs	10/31/19	0.00	2.94		
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					180 QC 10	2 pcs
QC 10 - 18						
QC 10 - 24	DAS					
QC 10 - 43	24					
QC 10 - 50	9-89					
					Plex 9/18/19 12:38 PM Dart.Renwick.Jennifer	

190 QC 5	2 pcs	10/31/19	0.00 0.00	QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
191 Handfinish - 2-1 Pressure-B4B	2 pcs	10/31/19	0.00 0.74	Handfinish - 2 - 1 - B4B	BEB 19-10-10.
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Powdercoat - 1 White G(A)-B4B	2 pcs	10/31/19	0.00 0.48	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BK 19-10-11.
				Powdercoat - 4 - B4B	
210 QC 3	2 pcs	10/31/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BEB 19-10-11
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
220 Handfinish - 4-1-Assembly-B4B	2 pcs	10/31/19	0.00 0.74	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BEB 19-10-11

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					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
230	QC 5	2	10/31/19	0.00 0.00	QC 5 - 10	
	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
240	Packaging 3-1 - Stock - B4B	2	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	

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9-89

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78 OCT 16 2019
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
250 QC 21 - SA	2	10/31/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	68-6 OCT 16 2019
				QC 21 - SA - 53	12

Part Op 100 - (Fabricate per Drwg) 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8271 as Descriptions: per Dwg D2842 ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding

110 - (QC5- Inspect part completeness to step on W/O)

120 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842 2-Grind end cap weld flush 3- Open hole as per dwg and deburr(0.250")

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - (QC5- Inspect part completeness to step on W/O)

191 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)***Touch up step with alodine per qsi 005 prior to powder coat***

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

210 - (QC3- Inspect Part Finish)

220 - (Assemble as per dwg) 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: _____

230 - QC5- Inspect part completeness to step on W/O)

240 - (Identify as per dwg & Stock Location: _____)

250 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Steps - 1	5265 (214)
D2734	Step End Plate	2 pcs (1 ea)	100-Large Fab - Steps - 1	5198347
D2734	Step End Plate	2 pcs (1 ea)	100-Large Fab - Steps - 1	5114690
D3459-1	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	5008750
D3459-3	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	5113237-10
MS27039C1-07	Screw	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	5218154
NAS1149C0332R	Washer (AN960C10L)	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	5023251
NAS1329C3KB130	Insert	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	5214921
NAS1515H3L	Washer	6 Ea (3 ea)	220-Handfinish - 4-1-Assembly-B4B	

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	2	87	0
	D2734	4	45	0
	D3459-1	4	12	0
	D3459-3	4	13	0
220-Handfinish - 4-1-Assembly-B4B	MS27039C1-07	6	30	0
	NAS1149C0332R	6	2,998	0
	NAS1329C3KB130	6	69	0
	NAS1515H3L	6	43	0
Part Specifications				
Specifications could not be found.				

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

[illegible]